

* Date: Thursday, 08/01/2009 1:43:34 PM
User: Julie Dawson

Process Sheet

Customer: : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
Job Number : 44506A
Estimate Number : 10522
P.O. Number :
This Issue : 08/01/2009 S.O. No. :
Prsht Rev. : NC Part Number : D206642441
First Issue : / / Type : SKIDTUBES Drawing Number : D2650 REV E
Previous Run : 41733A Drawing Revision : E
Material :
Due Date : 10/02/2009 Qty: 1 Um: Each
Written By :
Checked & Approved By : JUD 09.01.08
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
Est Rev: I 08-05-01 add QC3 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2620 Bent Tube 3" OD 44502

SL 9-1-9

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2647 Fwd Cap 343846

BE 9-1-9

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m109560/m109213 BE 9-1-9

4-Grind weld flush to cap on top surface only. BE 9-1-9

SL 9-1-9

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

28-1-10

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Avm 9-1-12



1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Avm 09-01-12

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B-44549

Avm 7-1-12

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 7-1-12 Time: 4:00

Finish Date: 9/1/12 Time: 6:45am

Avm 7-1-12

pm 09-01-12

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Job Number: 44506A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expiry date:

m109883
9-2-11

AWM

9-1-12

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/01/14 *20*

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

344276 *(8)*

344323 *(15)*

BE 09/01/14

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

m109213

BE 09/01/14

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

> Pmc 09-01-14

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

634599

Pmc 09-01-14

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS33

Rivets

m116122

Pmc 09-01-14

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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets m 106167

Am 09-01-17

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Am 09-01-14

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/06/14

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/14

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

Touch up Alodine a.m 09-01-15

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME GREY

B110199

-SPRAY PAINT DELFLEET BLUE

B110077

-CLEAR DELFLEET

B110161

ml 09 01 22 (1)

20.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

09-01-23

21.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B43989

W 09-07-05

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Job Number: 44506A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe B413991

jel

23.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B44281

jel

24.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe B44159

jel

25.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B44169

el

26.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts M1105819

or (see QSI 017)

yl 09-02-05 *el*

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Job Number: 44506A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD10L

Washer



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M1109632

SM

28.0

MS27039108

Screw



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

62 MS27039-1-08

Screw

M110467

SM

29.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

BLUE

Plugs

B45490

X

WMO / JH

09/02/24

30.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B43849

X

WMO / JH

09/02/24

31.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M1108161

JH

09-02-05

(1)

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Job Number: 44506A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M1109061

21

33.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

BLUE

Aft Cap

1343801

21

34.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M1110110

Sikaflex expiry date:

09/07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M1110110

Sikaflex expiry date:

09/07

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M1101454

21 09-02-06 21

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/24 21

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Process Sheet

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44506A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

2PP 44506

9/1/24

SDX
09/02/24

37.0

QC21

FINAL INSPECTION/W/O RELEASE

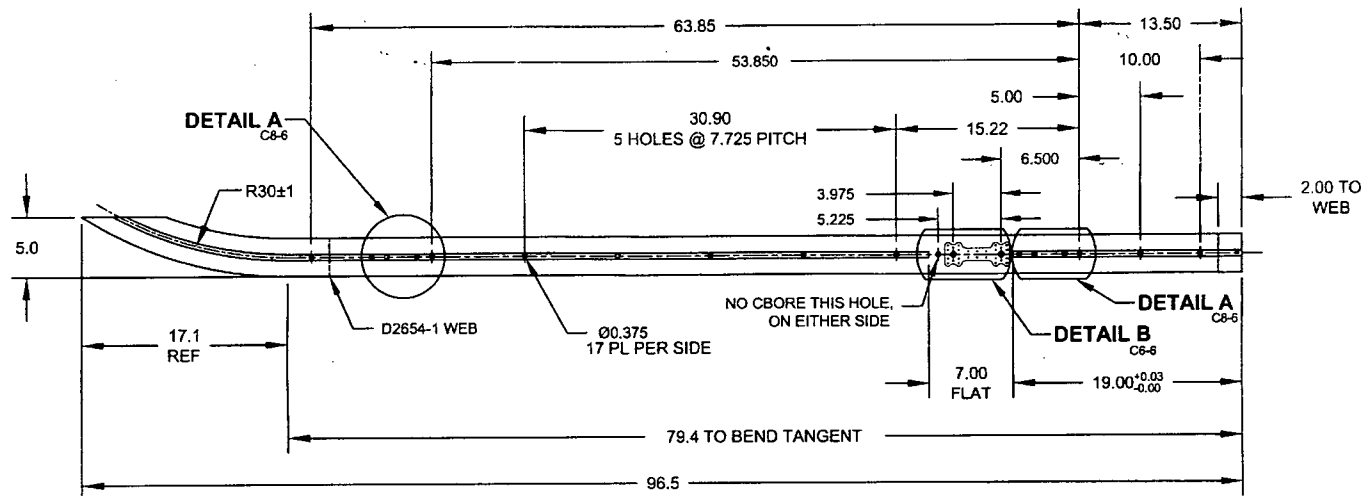


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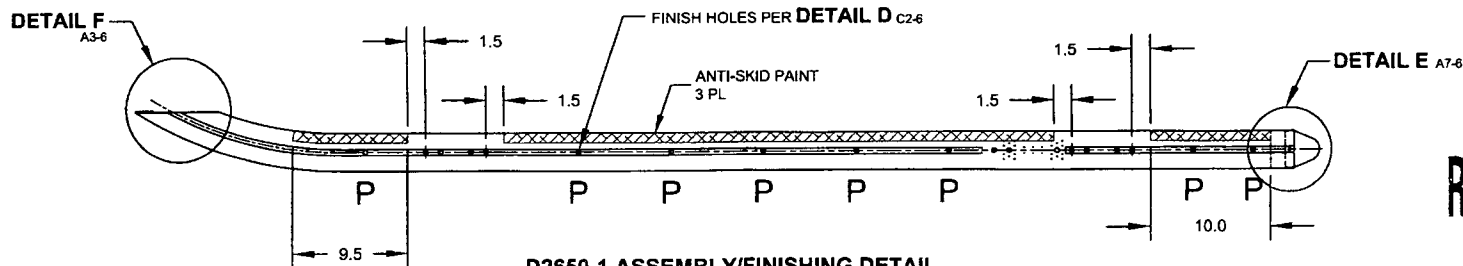
Job Completion



U 09.02.24



D2650-1 BENDING/DRILLING DETAIL

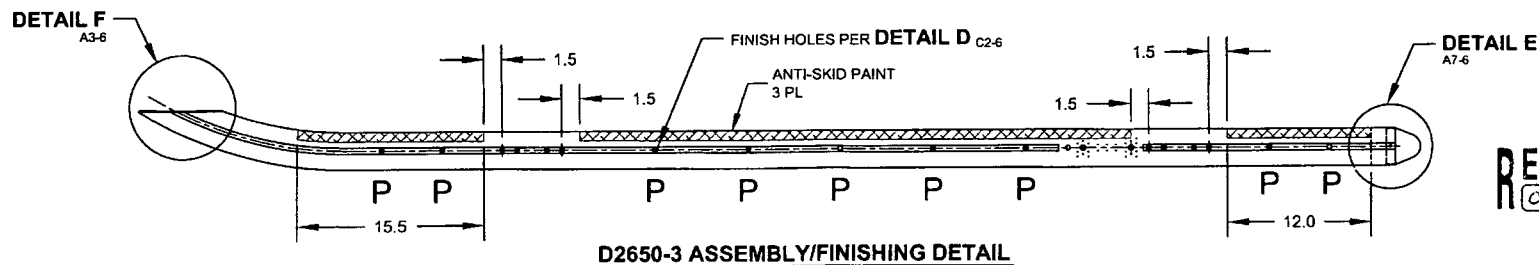
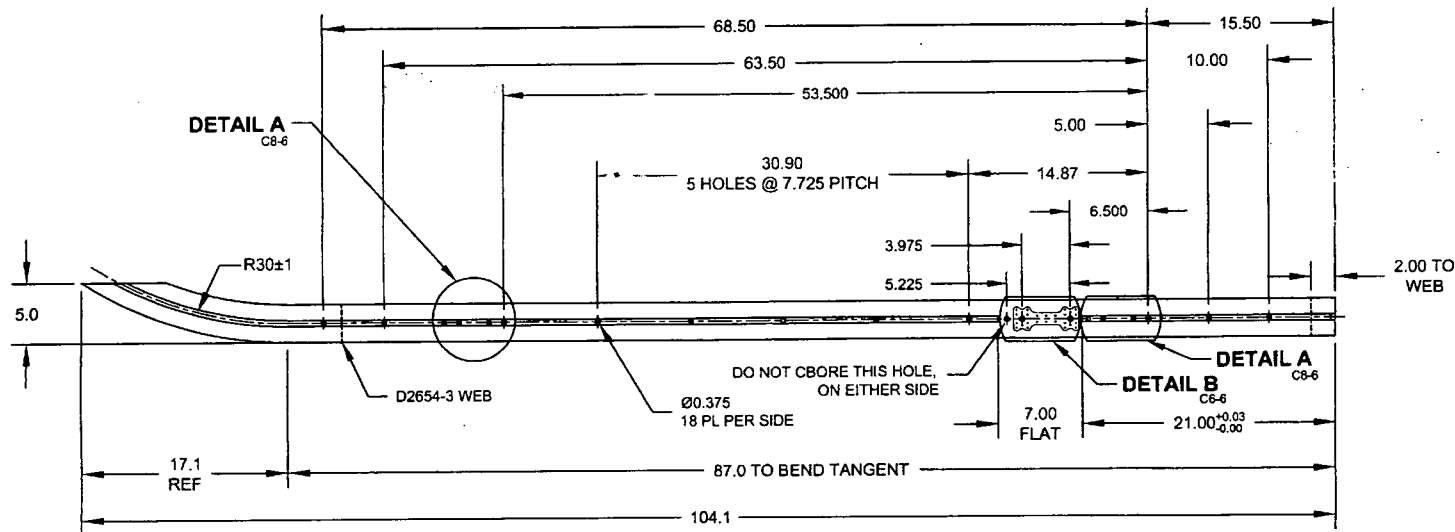


D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
68 09 22 / 117

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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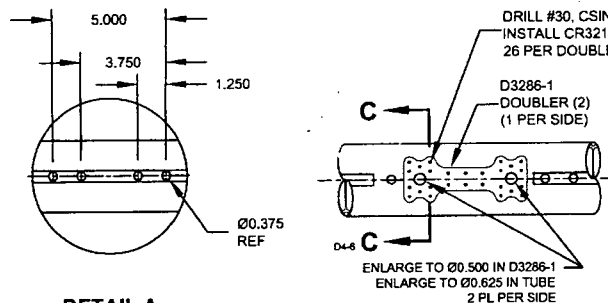
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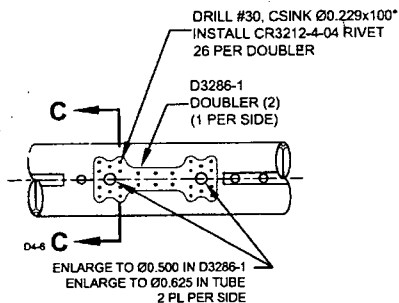
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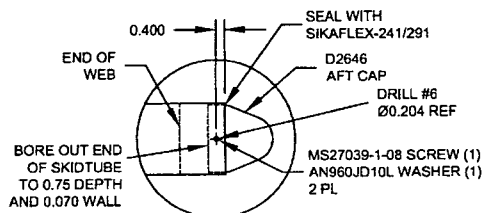
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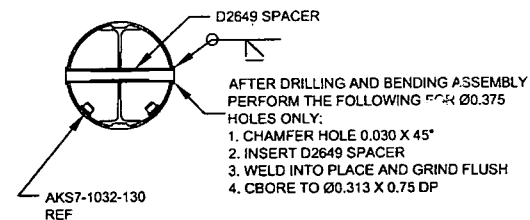
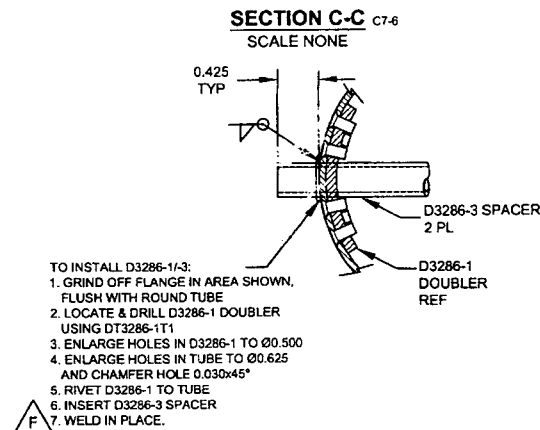
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



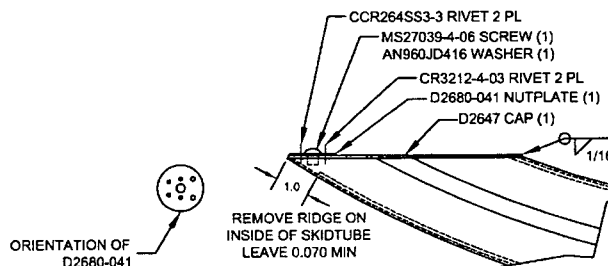
DETAIL B
SCALE 2X
C3-2
C3-3



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5






DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL F
SCALE NONE
B6-2
B6-3
B6-4
B6-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED

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NO. 186

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B44225A
Part number: A206-642-241
Description: 206 SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Nurb Date of Test Coupon 09/01/08
Welder Barclay Elliot Date of Test Coupon 09/01/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld